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Zanella et al.

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(54) **ROLLING PLANT, ROLLING MILL AND ROLLING METHOD**

(71) Applicant: **SMS INNSE S.P.A.**, San Donato Milanese (IT)

(72) Inventors: **Guido Emilio Zanella**, Milan (IT); **Vincenzo Palma**, Sesto San Giovanni (IT); **Marco Ghisolfi**, Muggiò (IT)

(73) Assignee: **SMS INNSE S.P.A.**, San Donato Milanese (IT)

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Primary Examiner — David B Jones
(74) *Attorney, Agent, or Firm* — Perkins Coie LLP; Viola T. Kung; Andrew T. Pettit

(57) **ABSTRACT**

The invention relates to a pipe rolling plant **10** comprising a rotary piercer **20**, a treatment station **30** and a main rolling mill **40**. The rotary piercer and the treatment station are arranged so that the pierced blank **51** leaving them is arranged with the irregular tail **511** facing the main rolling mill **40** and with the regular head **510** facing the mandrel **41**. The invention also relates to a rolling mill **40** comprising a plurality of rolling stations **43**, each station comprising a plurality of rolling rolls **42**, the radial position h of which is adjustable. The rolling mill also comprises a control circuit for calculating and/or measuring the distance d between the axes of rotation r of the rolls and the trailing edge **520** of the pipe **52**. The control circuit is also designed to displace the rolling rolls radially towards the outside of the pipe in each rolling station 43_n when the distance d assumes a predetermined value d_0.

4 Claims, 5 Drawing Sheets